



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3301
Job Sheet 186711



Part No: 646.3301

Job Qty: 12 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.3300 REV NC3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER
DWG NC3 DD VERF:JLM

Ship Via:

1506

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		12/21/18	0.00	0.00	Start Up Stores/Pkg-2		JAN 21 2019
110	Packaging	12 pcs		12/21/18	0.00	0.00	Packaging1-1		JAN 21 2019
120	Small Fab	12 pcs		12/21/18	0.00	16.67	Small Fab-1		JAN 21 2019
130	QC	12 pcs		12/21/18	0.00	0.00	QC5		JAN 21 2019
140	Packaging	12 pcs		12/21/18	0.00	0.00	Packaging3-1		JAN 21 2019
150	QC21-SA	12 Ea		12/21/18	0.00	0.00	QC21		JAN 21 2019

Part Op 120 - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying
Descriptions: surfaces shown on dwg per note 7. exp. date: 10/20

140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	4 12 Ea (1 ea)	90-Start up Operation	5108/99
646.3311	RH Half - Upper Cutter Assembly	4 12 Ea (1 ea)	90-Start up Operation	5108/605
646.3312	Center Plate	4 12 Ea (1 ea)	90-Start up Operation	5093391
646.3313	Upper Guide	4 12 Ea (1 ea)	90-Start up Operation	512783/11 512774323
646.3314	Blade	4 12 Ea (1 ea)	90-Start up Operation	5130632
646.3315	Blade	4 12 Ea (1 ea)	90-Start up Operation	5130528
646.3316	Blade	4 12 Ea (1 ea)	90-Start up Operation	5130582
AN3-12A	Bolt	8 24 Ea (2 ea)	90-Start up Operation	5095479
AN3-14A	Bolt	4 12 Ea (1 ea)	90-Start up Operation	5118190
MS21042L08	Nut	12 216 Ea (18 ea)	90-Start up Operation	5080644
MS21042L3	Nut	12 36 Ea (3 ea)	90-Start up Operation	5132364
MS27039-08-19	Screw	12 216 Ea (18 ea)	90-Start up Operation	5104359
NAS1149F0332P	Washer	2 72 Ea (6 ea)	90-Start up Operation	5133206
NAS1149FN832P	Washer	1 432 Ea (36 ea)	90-Start up Operation	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3310	12	10	0
	646.3311	12	11	0
	646.3312	12	9	0

DQA: _____ Date: _____

WORK ORDER NON CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rev S Use- Suspected Unappro
Part No. _____	
NCR No. _____	

Date :	Step #:
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Description Work Order Deviation

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DART
AEROSPACE

1270 Aberdeen Street
Hemel Hempstead, HX4 1K7
UK
TEL: 013 632-5200
Email: sales@dartaero.com
www.dartaero.com

Part: 646.3301
Job No: 186711
Serial No/Batch: S146373

Revision:
Inspector:
Exp Date:
Instructions:

Container No: S146373

Date: 01/22/19

Approval

Root Cause			FAULT CATEGORY					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER :					
Misidentified	☐	Past Due						

646.3313	12	2	0
646.3314	12	4	0
646.3315	12	4	0
646.3316	12	5	0
AN3-12A	24	82	0
AN3-14A	12	306	0
MS21042L08	216	1,084	0
MS21042L3	36	1,662	0
MS27039-08-19	216	1,246	0
NAS1149F0332P	72	1,017	0
NAS1149FN832P	432	1,511	0

Part Specifications

Specifications could not be found.

Plex 11/20/18 12:43 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								